



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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D5556-041
Job Sheet 184509



Part No: D5556-041

Job Qty: 4 ea

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/11/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D5556 REV.B IPP REV:A 18.02.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.23 AS PER DWG REV.B DD VERF:JFS

Ship Via:

6236

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	10/31/18	10/31/18	0.00	0.00	Start Up Small Fab-4	8:00	NOV 07 2018
110	Small Fab	4 pcs	10/31/18	10/31/18	0.00	1.73	Small Fab-3	8:00	NOV 09 2018
120	QC	4 pcs	10/31/18	10/31/18	0.00	0.00	QC5	8:00	NOV 09 2018
130	Packaging	4 pcs	10/31/18	10/31/18	0.00	0.00	Packaging3-2	8:00	NOV 09 2018
140	QC21-SA	4 Ea	10/31/18	10/31/18	0.00	0.00	QC21	8:00	NOV 09 2018

Part Op 110 - ASSEMBLE AS PER DWG AND APPLY RTV TO ALL FAYING SURFACES (SEE NOTE 8) RTV 598
Descriptions: BATCH: _____

DAS
21
9-89

NOV 09 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5557-1	Cutter Blade	8 Ea (2 ea)	90-Start up Operation	5044579
D5573-1	Base Bracket, Upper, Cable Cutter, LH	4 Ea (1 ea)	90-Start up Operation	5112338
D5573-2	Base Bracket, Upper, Cable Cutter, RH	4 Ea (1 ea)	90-Start up Operation	5117496
D5574-1	Blade Housing, Cable Cutter	4 Ea (1 ea)	90-Start up Operation	5122691
D5576-1	Deflector, Upper, Cable Cutter	4 Ea (1 ea)	90-Start up Operation	51190122-5124046
MS21042L08	Nut	40 Ea (10 ea)	90-Start up Operation	5150489
MS27039-08-19	Screw	24 Ea (6 ea)	90-Start up Operation	5104357
MS27039-08-24	Screw (MS27039-0824)	16 Ea (4 ea)	90-Start up Operation	5098209
NAS1149DN832J	Washer	80 Ea (20 ea)	90-Start up Operation	5034411

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5557-1	8	14	0
	D5573-1	4	0	0
	D5573-2	4	0	0
	D5574-1	4	4	0
	D5576-1	4	2	0
	MS21042L08	40	2,392	0
	MS27039-08-19	24	2,064	0
	MS27039-08-24	16	259	0
	NAS1149DN832J	80	1,091	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation	Disposition

Part: D5556-041
Job No: 184509
Serial No/Batch: S125718
Revision: B
Inspector: _____
Exp Date: _____
Instructions: Various STC's

Container No: S125718

Date: 11/07/18

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 CANADA
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 www.dartaerospace.com

Root Cause		FAULT CATEGORY	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐

Part Specifications

Specifications could not be found.

Plex 10/11/18 8:40 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								